

CLAIMS

1. Process for bending on a frame glass sheets intended for assembly forming a laminated glazing unit, at least one of the sheets bearing patterns of enamelling composition that have not been pre-sintered, the other sheet bearing functional layers, the enamel patterns and the functional layers being on the faces of the sheets in contact with one another, characterised in that, during passage through the bending oven, in a first time phase, the sheets are arranged one on top of the other while maintaining a space between them for the period corresponding to sintering under the action of increasing temperature, then before the temperature for softening the sheets has been reached, these are put back one directly on top of the other for the remainder of the bending operation.
2. Process according to claim 1, wherein in the first time phase, the sheets are held at a distance from one another that does not exceed 5 cm.
3. Process according to claim 1, wherein in the first time phase, the sheets are held at a distance from one another that does not exceed 3 cm.
4. Process according to one of the preceding claims, wherein in the first time phase the distance separating the sheets is not less than 5 mm.
5. Process according to one of the preceding claims, wherein in the first time phase the distance separating the sheets is not less than 10 mm.
6. Process according to one of the preceding claims, wherein the sheets are put back one on top of the other at a temperature that is not higher than 580°C.
7. Process according to one of the preceding claims, wherein the sheets are put back one on top of the other at a temperature that is not higher than 550°C.
8. Process according to one of the preceding claims, wherein the sheets are put back one on top of the other at a temperature that is not lower than 400°C.
9. Process according to one of the preceding claims, wherein the sheets are put back one on top of the other at a temperature that is not lower than 450°C.

10. Process according to one of the preceding claims, wherein the sheet bearing the enamelling composition is subjected directly to the bending process directly after application of these patterns.

11. Process according to one of claims 1 to 8, wherein the sheet bearing the enamelling composition is subjected to a drying operation prior to bending, the temperature and the drying time being insufficient to eliminate all the organic constituents.

12. Bending frame for implementing the process according to any one of the preceding claims, which, in addition to the frame having for the purpose of the operation the profile of the desired glazing and said frame supporting one of the two sheets at the beginning of the bending process, comprises elements enabling the second glass sheet to be supported at a distance above the first sheet, during a first time phase, then, in a second time phase, these same means may be moved away to release the second glass sheet, which then comes to rest on the first sheet.

13. Frame according to claim 10, wherein the support elements are arranged on the periphery of the sheet to support the sheet over at least one section of the periphery so that the upper sheet hardly flexes and maintains an adequate distance over its entire surface from the lower sheet.

14. Bent laminated glazing obtained through the process according to one of claims 1 to 11.